

Work Order ID 137432 - 2

137432

Page 1

Wednesday, September 30, 2015 12:26:03 P

Item ID: D407-605-045 *SPLIT* Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: *Rev 3* Stop ***NS2***
 Item Name: Rear Locker Extender
 Start Date: 9/30/15 Start Qty: 7.00 ***7*** Cust Item ID:
 Required Date: 10/09/15 Req'd Qty: 7.00 ***7*** Customer:
 Reference: REWORK (REPAINTED)

Approvals: Process Plan: *[Signature]* Date: *159-30* Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4738	A								

105

0.00

105

QC

Quality Control

Memo

0.00

PULL FROM STOCK

D407-605-045 X7

BATCH:

100218

100220

100221

100222

100223

100224

100225

TO BE REWORK

D46
6
9-30

OCT 29 2014

noceived ————— *y/k.* *SP 15-10-29.*

Work Order ID 137432***137432***

Wednesday, September 30, 2015 12:26:03 P

Item ID: D407-605-045

Accept

N900040100

Setup Start *N

Revision ID:

Stop *N

Item Name: Rear Locker Extender

Start Date: 9/30/15 Start Qty: 7.00

7

Cust Item ID:

Required Date: 10/09/15 Req'd Qty: 7.00

7

Customer:

Reference: REWORK (REPAINTED)

Run Start *N

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *N

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number
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110

0.00

110

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 29950

Supplier: FDC.

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

115

0.00

115

Outsource7

Memo

0.00

Outsource rework

REWORK AS PER QUOTE 1278
REPAINT FINISH + TOOLING

See page 1
MLJ
15-11-23

PD

CL SEP 30 2015 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>137432</u> Part No. <u>D4738-1</u> NCR No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☒</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☒																

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		15.11.06	115	4	D4738-1 REAR LOCKERS (D407-605-045) GELCOAT WAS CRACKED.	A.P. 15.11.06	SAND GELCOAT TO REMOVE CRACKS, APPLY PPG 6941241A 2C ACRYCOTE WHITE PAINT WITH CATALYST PPG 794002 2C ACRYCOTE. SEE ATTACHED RUN TEST FOR D206-605-043 WHICH HAS THE SAME LAYUP. FAR 25.855 (d) compliance acceptable deviation			
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Order ID 137432

137432

Page 3

Tuesday, September 30, 2015 12:26:03 P

Item ID: D407-605-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rear Locker Extender

Start Date: 9/30/15 Start Qty: 7.00

7

Cust Item ID:

Required Date: 10/09/15 Req'd Qty: 7.00

7

Customer:

Reference: REWORK (REPAINTED)

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC3- Inspect Part Finish	0.00							DAS 9 9-30
125		0.00				①	15-11-25		
QC	Memo								
Quality Control									
150		0.00							
150	Packaging	0.00				IX		DAS 28 9-30	NOV 20 2015
Packaging	Memo								
Packaging	REPACKAGE UNDER NEW BATCH NUMBER								
	FG 104								
160	QC21- Final Inspection - Work Order Release	0.00							
160		0.01				MLJ	15-11-24		
QC	Memo								
Quality Control									

20151120

Picklist Print

Wednesday, September 30, 2015 12:26:07 PM

Page 1

Work Order ID: 137432

137432

Parent Item: D407-605-045

D407-605-045

Parent Item Name: Rear Locker Extender

Start Date: 9/30/15

Required Date: 10/09/15

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A 13.04.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D407-605-045		Manufactured		No			Each	0.0000		7			

D407-605-045

Rear Locker Extender

**

7 9-30

B: 100218 X1
220 X1
221 X1
222 X1
223 X1
224 X1
225 X1

DAS
28
9-89

NAS11490W 8161
W526 C832R8

128057 X 24
129764 X 10 + 82
129706 X 6
2



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19950

Purchase Order Date 9/30/2015

PO Print Date 9/30/2015

Page Number 1 of 2

Order From : FDC COMPOSITES INC. 45 CHEMIN DE L'AEROPORT LOCAL 26 ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5	VC-FDC01	Ship To : DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CANADA
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Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Customer POID	
450-357-1344 ext303	Customer Tax #	10127-2607
Ship To Contact	Terms	Net 30
Ship To Phone	Currency	CAD
Ship Via:	FOB	Destination-Collect
Ship Acct:		

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	137432	D407-605-045 REAR LOCKER REWORK D407-605-045 REAR LOCKER, RE-PAINTING B100218 ✓ B100220 ✓ B100221 ✓ B100222 ✓ B100223 ✓ B100224 ✓ B100225 ✓	10/16/2015 Yes 10/16/2015	7.00	\$195.00	\$1,365.00
Line Total:						\$1,365.00
2	137433	D206-605-043 REAR LOCKER RE-WORK D206-605-043 REAR LOCKER, RE-PAINTING B100228 ✓ B100229 ✓ B100230 ✓ B100231 ✓	10/16/2015 Yes 10/16/2015	4.00	\$195.00	\$780.00

PO Instructions: QUOTATION NO. 1278

Note:

9/30/2015

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél. : 450 357-1344

Bon de livraison

27/10/2015

Commande : 2275
Référence : PO #29950/1

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

Même

Tél.: 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D407-605-045	REAR LOCKER EXTENDER PO item: 29950/1 Lot: B100218 B100223 B100224 B100225	4 ✓	_____	_____

SPIS-09-29.

Transport : _____

Réf. : _____

Nb colis : _____

Marchandise reçue : _____



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 29950

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Vendor Part Number</u>	<u>Description</u>	<u>Lot</u>
1	4	D407-605-045	137432	Rear Locker Extender	B100218 B100223 B100224 B100225

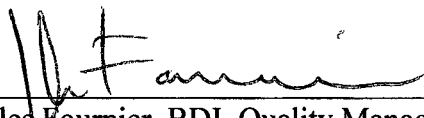
NOTE :

Operation performed : interior surface re-painting as specified on Darts's PO by sanding gelcoat to remove cracks and application of PPG 6941241A 2C Acrycote White paint Lot 00022.
Catalyst was PPG 794002 2C Acrycote Lot 98841.

Catalysed PPG acrycote paint complies with FAR 25.853 Appendix F Part I (b)-Par.4 (Vertical Test 60 seconds). See attached Analysis Report from CTT Group.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:


Jules Fournier, BDI, Quality Manager

Date: 2015-10-27



Kmlx Aviation Inc.
5650 Dessiant, Ville St-Laurent, Quebec,
Canada, H4S 1A6

Tel: 514-227-1693, Fax: 514-227-1694

Flammability Test Results

30 SEC.-45°-FAR 25.853(h), 25.855(d), APPENDIX F PART I(a)(2)(ii),(iii)

Customer: Dart Aerospace
Item tested: Rear Locker Extender B/N 137433
Part No.: D206-605-043 Side Tested: S1
PO No.: 30202 Report No.: 35136-003

Flame Temperature (Min 1550 F): 1764 F

Results	Fill			Warp		
	EXTINGUISH TIME [SECONDS]	AFTER GLOW [SECONDS]	FLAME PENETRATION	EXTINGUISH TIME [SECONDS]	AFTER GLOW [SECONDS]	FLAME PENETRATION
1	2.30	0.00	NP		0.00	NP
2	1.70	0.00	NP			
3	0.00	0.00	NP			
4						
5						
6						
Average	1.33	0.00	NP			

Criteria: Per FAR 25.853, Appendix F Part I

Test Type	EXTINGUISH TIME [SECONDS]	AFTER GLOW [SECONDS]	FLAME PENETRATION
F5	15	10	NP



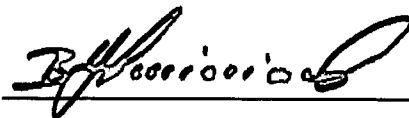
Pass



Fail

Tested by: M. Banbula

Date: 22-Oct-15

Witness by: 

Bogdan Kmiecik



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 29950

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Vendor Part Number</u>	<u>Description</u>	<u>Lot</u>
1	4	D407-605-045	137432	Rear Locker Extender	B100218 B100223 B100224 B100225

NOTE :

Operation performed : interior surface re-painting as specified on Darts's PO by sanding gelcoat to remove cracks and application of PPG 6941241A 2C Acrycote White paint Lot 00022.
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